

Date: Tuesday, 03/03/2009 3:41:56 PM  
 User: Julie Dawson

## Process Sheet

<b>Customer</b> : CU-DAR001 Dart Helicopters Services	<b>Drawing Name</b> : SWING ARM
<b>Job Number</b> : 46263	
<b>Estimate Number</b> : 11303	
<b>P.O. Number</b> :	<b>Part Number</b> : D34479
<b>This Issue</b> : 03/03/2009 <b>S.O. No.</b> :	<b>Drawing Number</b> : D3447
<b>Prsht Rev.</b> : NC	<b>Project Number</b> : N/A
<b>First Issue</b> : / / <b>Type</b> : MACHINED PARTS	<b>Drawing Revision</b> : A
<b>Previous Run</b> : 45018	<b>Material</b> :
<b>Written By</b> :	<b>Due Date</b> : 10/03/2009 <b>Qty:</b> 20 <b>Um:</b> Each
<b>Checked &amp; Approved By</b> : <u>JLD 09.03.03</u>	
<b>Comment</b> : Est A 05.08.26 New issue KJ/JLM	

## Additional Product

Job Number:



Seq. #: Machine Or Operation:

Description :

1.0

M7075T6B1500X1500

7075 T6 BAR 1.500 x 1.500

**Comment:** Qty.: 0.7350 f(s)/Unit Total : 14.7000 f(s)

7075 T6 BAR

Material: 7075-T6 Bar (QQ-A-200/8 or QQ-A-225/8)

{ (M7075T6B1.500x01.500);

Identify for D3447-9

Batch: M110778 x16JL 09/03/04

2.0

BAND SAW

BAND SAW

**Comment:** BAND SAW

Cut blanks: 1.500" x 1.500" x 8.400" long

JL 09/03/04

3.0

HAAS1

HAAS CNC VERTICAL MACHINING #1

**Comment:** HAAS CNC VERTICAL MACHINING #1

Machine as per Folio FA544 and Dwg B67-43001

Identify as D3447-9Dwg Rev 4 Folio Rev AA

Deburr

JTP 09/03/0516

4.0

QC2

INSPECT PARTS AS THEY COME OFF MACHINE

**Comment:** INSPECT PARTS AS THEY COME OFF MACHINEJTP 09/03/0516

5.0

QC8

SECOND CHECK

**Comment:** SECOND CHECKM.A 09/03/0616

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_

Resolution: \_\_\_\_\_ Disposition: \_\_\_\_\_ QA: N/C Closed: \_\_\_\_\_ Date: \_\_\_\_\_

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

**NOTE:** Date & initial all entries

Date: Tuesday, 03/03/2009 3:41:56 PM  
User: Julie Dawson

## Process Sheet

Customer: CU-DAR001 Dart Helicopters Services

Drawing Name: SWING ARM

Job Number: 46263

Part Number: D34479

Job Number:



Seq. #:

Machine Or Operation:

Description :

6.0

HAND FINISHING1

HAND FINISHING RESOURCE #1



Comment: HAND FINISHING RESOURCE #1

Chemical Conversion Coat as per QSI 005 4.1

*ump/BL.*

*09/03/09*

*(16)*

7.0

POWDER COATING

POWDER COATING



Comment: POWDER COATING

Powder Coat Green Sandtex (Ref: 4.3.5.8) as per QSI 005 4.3

Mask inside holes as per Dwg D3447 prior to painting

*M 18144.*

*(16)*

START TIME:

*8:45*

OVEN TEMPERATURE:

*320°*

FINISH TIME:

*9:45*

*FX*

*09-03-9*

8.0

QC3

INSPECT POWDER COAT/CHEMICAL CONVERSION



Comment: INSPECT POWDER COAT/CHEMICAL CONVERSION

*FX 09/03/09*

*(12)*

9.0

PACKAGING 1

PACKAGING RESOURCE #1



Comment: PACKAGING RESOURCE #1

Identify and Stock

Location: *442*

*9/3/10*

*(105)*

*29*

10.0

QC21

FINAL INSPECTION/W/O RELEASE



Comment: FINAL INSPECTION/W/O RELEASE

*09/03/10*

Job Completion



*MF 09-03-10*

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_

Resolution: \_\_\_\_\_ Disposition: \_\_\_\_\_ QA: N/C Closed: \_\_\_\_\_ Date: \_\_\_\_\_

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

**NOTE:** Date & initial all entries

<b>DART AEROSPACE LTD</b>		<b>Work Order:</b> 46263
<b>Description:</b> Swing Arm		<b>Part Number:</b> D3447-9
<b>Inspection Dwg:</b> D3447	<b>Rev:</b> A	<b>Page 1 of 1</b>

### FIRST ARTICLE INSPECTION CHECKLIST

☒ First Article ☐ Prototype

Drawing Dimension	Tolerance	Actual Dimension	Accept	Reject	Method of Inspection	Comments
8.02	+/-0.030	8.02	✓			
7.075	+/-0.005	7.075	✓			
R0.38	+/-0.030	0.380	✓			
Ø0.375	+0.006/-0.001	0.375	✓			
0.75	+/-0.030	0.749	✓			
0.375	+/-0.005	0.375	✓			
0.470	+/-0.005	0.470	✓			
1.100	+/-0.010	1.105	✓			
0.71	+/-0.030	0.704	✓			
0.178	+/-0.010	0.177	✓			
1.825	+/-0.010	1.825	✓			
2.375	+/-0.010	2.375	✓			
R0.25	+/-0.030	0.250	✓			
R0.13	+/-0.030	0.130	✓			
3.700	+/-0.010	3.700	✓			
0.25	+/-0.030	0.252	✓			

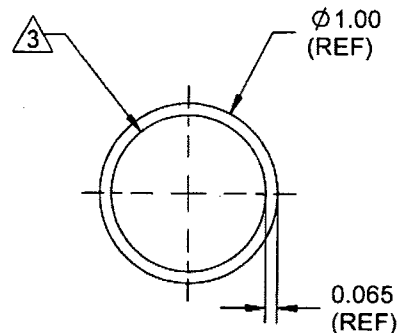
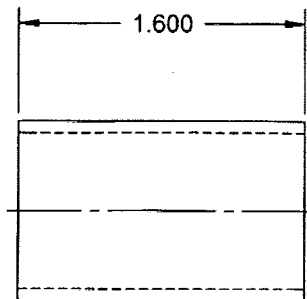
<b>Measured by:</b> DJP	<b>Audited by:</b> H.A	<b>Prototype Approval:</b>	N/A
<b>Date:</b> 09/03/05	<b>Date:</b> 09/03/06	<b>Date:</b>	N/A

Rev	Date	Change	Revised by	Approved
A	08.07.24	New Issue	KJ/DD	

**DART**

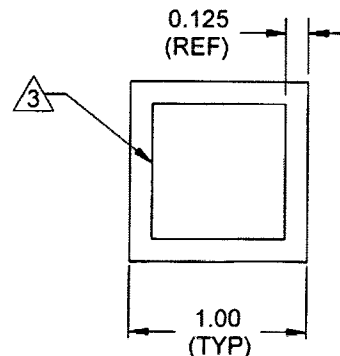
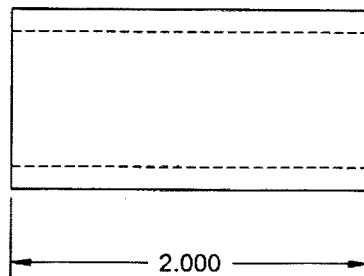
DESIGN 3	DRAWN BY 3	<b>DART AEROSPACE LTD</b> HAWKESBURY, ONTARIO, CANADA	
CHECKED JH	APPROVED JH	DRAWING NO. <b>D3447</b>	REV. A SHEET 1 OF 4
DATE <b>05.07.19</b>		TITLE <b>BLADE FOLD KIT PARTS</b>	SCALE 1:1
A	05.07.19	NEW ISSUE	

RELEASED  
05/03/18



### **D3447-1 ROUND SPACER**

- 1) MATERIAL: 6061-T6 OR 6061-T62 TUBING PER WW-T-700/6 OR AMS 4080 OR AMS 4082 OR QQ-A-200/8 OR QQ-A-225/8 (REF. DART SPEC. M6061T6T1.000W.065)



### **D3447-3 SQUARE SPACER**

- 1) MATERIAL: 6061-T6 (OR 6061-T651/ T6510/ T6511/ T62) SQUARE TUBING PER AMS-QQ-A-225/8 (OR AMS 4117/ 4128/ 4115/ 4116) OR PER AMS-QQ-200/8 (OR AMS 4160) (REF. DART SPEC. M6061T6TS1.000W.125)

### **NOTES:**

- 2) CHEMICAL CONVERSION COAT PER DART QSI 005 4.1
- 3) MASK INSIDE OF TUBING BEFORE PAINTING.
- 4) FINISH: POWDER COAT PAINT GREEN SANDTEX (4.3.5.8) PER DART QSI 005 4.3
- 5) TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED
- 6) ALL DIMENSIONS ARE IN INCHES
- 7) BREAK ALL SHARP EDGES 0.005 TO 0.010

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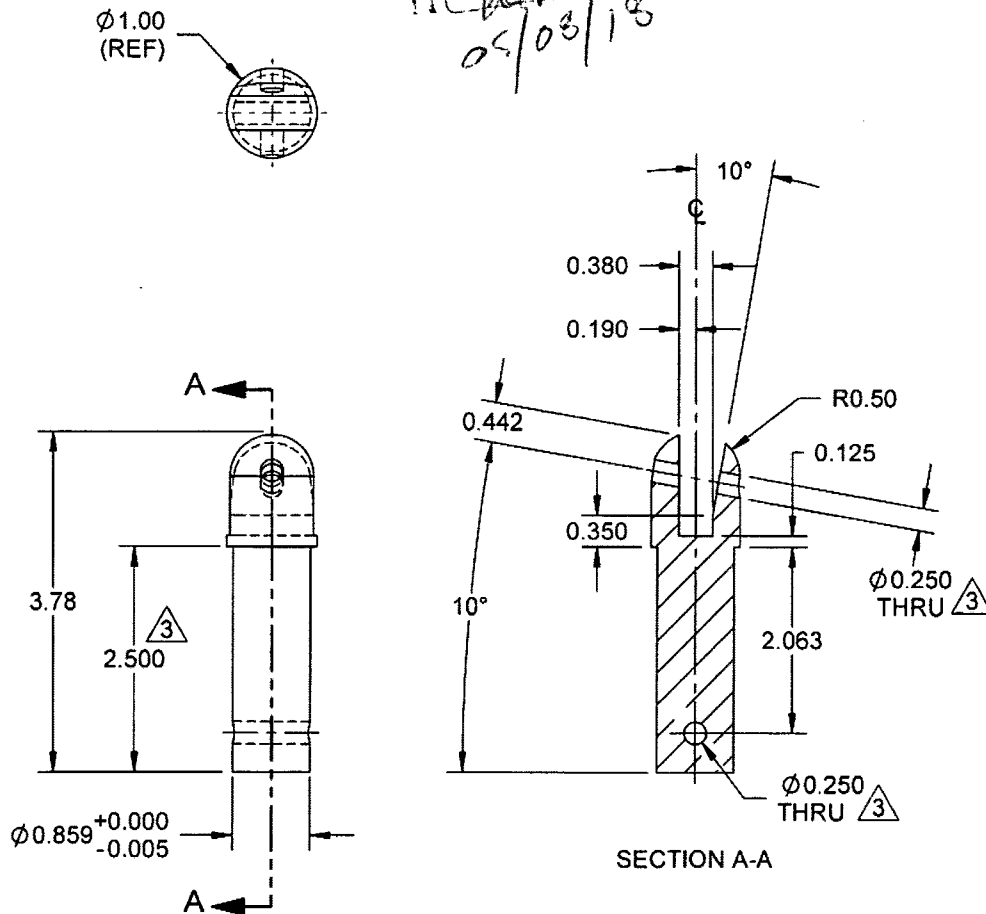
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**DART**

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CHECKED <i>[Signature]</i>	APPROVED <i>[Signature]</i>	DRAWING NO. <b>D3447</b>	REV. A SHEET 2 OF 4
DATE <b>05.07.19</b>	TITLE <b>BLADE FOLD KIT PARTS</b>		SCALE 1:2



**D3447-5 CLEVIS**  
**SUPERSEDES PREMIER P/N B67-43001-99**

**NOTES:**

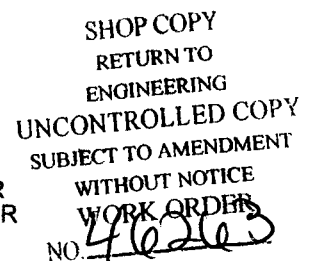
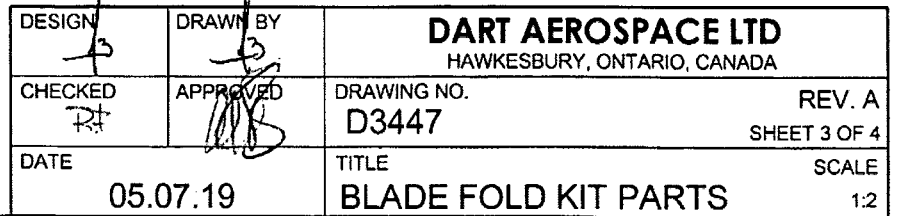
- 1) MATERIAL: 6061-T6 (OR 6061-T651/T6510/T6511/T652) ROUND BAR  
PER AMS-QQ-A-225/8 (OR AMS 4117/4128/4115/4116) OR NO. *40203*  
PER AMS-QQ-A-200/8 (OR AMS 4160)  
(REF. DART SPEC. M6061T6R1.000)
- 2) CHEMICAL CONVERSION COAT PER DART QSI 005 4.1
- 3) MASK AND COVER INSIDE HOLES AS SHOWN PRIOR PAINTING
- 4) FINISH: POWDER COAT PAINT GREEN SANDTEX (4.3.5.8) PER DART QSI 005 4.3
- 5) TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED
- 6) ALL DIMENSIONS ARE IN INCHES
- 7) BREAK ALL SHARP EDGES 0.005 TO 0.010

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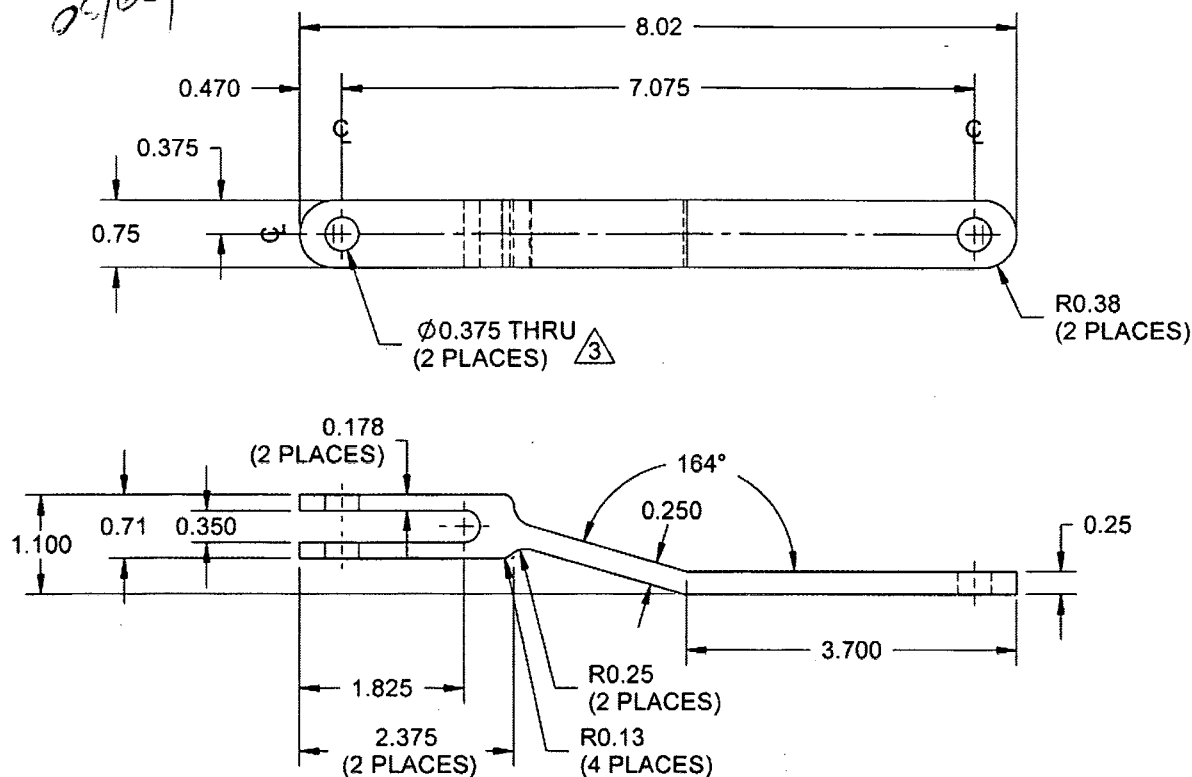
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CHECKED <i>[Signature]</i>	APPROVED <i>[Signature]</i>	DRAWING NO. <b>D3447</b>	REV. A SHEET 4 OF 4
DATE <b>05.07.19</b>	TITLE <b>BLADE FOLD KIT PARTS</b>		SCALE 1:2

*[Handwritten: RELEASED 05/08/18]*



**D3447-9 SWING ARM**  
**SUPERSEDES PREMIER P/N B67-43001-263**

**NOTES:**

- 1) MATERIAL: 6061-T6 (OR 6061-T651/T6510/T6511/T652) ROUND BAR  
PER AMS-QQ-A-225/8 (OR AMS 4117/4128/4115/4116) OR NO. *40263*  
PER AMS-QQ-A-200/8 (OR AMS 4160)  
(REF. DART SPEC. M6061T6B)
- 2) CHEMICAL CONVERSION COAT PER DART QSI 005 4.1
- 3) COVER INSIDE HOLES PRIOR PAINTING
- 4) FINISH: POWDER COAT PAINT GREEN SANDTEX (4.3.5.8) PER DART QSI 005 4.3
- 5) TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED
- 6) ALL DIMENSIONS ARE IN INCHES
- 7) BREAK ALL SHARP EDGES 0.005 TO 0.010

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